

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-019187**Date Inspected:** 03-Jan-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Liu Hua Jie**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG COMPONENT**Summary of Items Observed:**

On this day Caltrans OSM Quality Assurance (QA) Inspector Subhasis Bera was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhen Hua Port Machinery Company (ZPMC) at Chang Xing Island in Shanghai, China. QA Inspector observed and/or found the following:

In process Inspection

Trial Assembly

This QA Inspector observed the following work in progress:

SMAW in the 4G position for the OBG Segment 12AE for UT repair joint weld No.SEG3001A-004. The welder is identified as #044515. ZPMC QC is identified as Mr. Wang Li Yang. The welding variables recorded by QC appear to comply with WPS-345-SMAW-4G (4F)-FCM-REPAIR-1. The repair report is identified as WR19749.

SMAW in the 4G position for the OBG Segment 12BE for UT repair joint weld No.SEG3002A-001. The welder is identified as #050289. ZPMC QC is identified as Mr. Wang Li Yang. The welding variables recorded by QC appear to comply with WPS-345-SMAW-4G (4F)-FCM-REPAIR-1. The repair report is identified as WR19750.

SMAW in the 4G position for the OBG Segment 12AW to 12BW for UT repair joint weld No.OBW12D-002. The welder is identified as #040611. ZPMC QC is identified as Mr.Zhou Zhong Hai. The welding variables recorded by QC appear to comply with WPS-345-SMAW-4G (4F)-FCM-REPAIR-1. The repair report is identified as WR19740.

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

SMAW in the 4G position for the OBG Segment 12AW to 12BW for UT repair joint weld No.OBW12D-002. The welder is identified as #040611. ZPMC QC is identified as Mr.Zhou Zhong Hai. The welding variables recorded by QC appear to comply with WPS-345-SMAW-4G (4F)-FCM-REPAIR-1. The repair report is identified as WR19740.

SMAW in the 4G position for the OBG Segment 12BE for UT repair joint weld No.DP3018-001-009. The welder is identified as #044515. ZPMC QC is identified as Mr. Wang Li Yang. The welding variables recorded by QC appear to comply with WPS-345-SMAW-4G (4F)-FCM-REPAIR-1. The repair report is identified as WR18923.

During visual inspection at trial assembly area the QA inspector observed that the ZPMC personnel performing fit-up for bottom splice joint at segment between 12BE to 12CE. For preheat at fit up area the ZPMC personnel using heating torch. For details see the attached photo.

Visual Inspection Before install side cover plate

Visual inspection of internal welds and surface cleaning carried out before install the side cover plate, the bike path is identified as BK004A-0032. Locations where need additional grinding and cleaning marked and repaired work carried out ZPMC personnel.

Ultrasonic Testing (A,B,C and D-Scan)

This QA Inspector performed Ultrasonic testing (UT) verification of the area previously tested and accepted by ABF Quality control personnel. This QA inspector generated a (UT) report for this date. The member is identified as corner joint joining between edge Plate to Deck Plate for OBG segment 12AE at bike path side . The result was recorded onto a data sheet according to rejection criteria of “D” Scan procedure 001 rev.1 that Caltrans QA and ABF QA have jointly filled out on this date. The QA inspector found no rejectable indication at scanned area.

The Weld Designation is as follows

CA6501-006

This QA Inspector performed Ultrasonic testing (UT) verification of the area previously tested and accepted by ABF Quality control personnel. This QA inspector generated a (UT) report for this date. The member is identified as corner joint joining between edge Plate to Deck Plate for OBG segment 12BE at bike path side . The result was recorded onto a data sheet according to rejection criteria of “D” Scan procedure 001 rev.1 that Caltrans QA and ABF QA have jointly filled out on this date. The QA inspector found three(3) rejectable indication at scanned area.

The Weld Designation is as follows

CA3003-002

This QA Inspector performed Ultrasonic testing (UT) verification of the area previously tested and accepted by ABF Quality control personnel. This QA inspector generated a (UT) report for this date. The member is identified as corner joint joining between side Plate to bottom Plate for OBG crossbeam CB 19 at east side . The result was recorded onto a data sheet according to rejection criteria of “D” Scan procedure 001 rev.1 that Caltrans QA and

WELDING INSPECTION REPORT

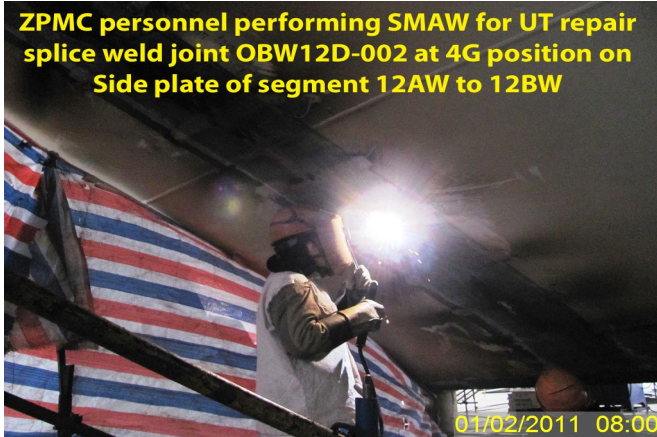
(Continued Page 3 of 3)

ABF QA have jointly filled out on this date. The QA inspector found no rejectable indication at scanned area.

The Weld Designation is as follows

CB3003A-019-017

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

No relevant conversations

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Bera,Subhasis	Quality Assurance Inspector
----------------------	---------------	-----------------------------

Reviewed By:	Dsouza,Christopher	QA Reviewer
---------------------	--------------------	-------------
